

Technical Data and Settings

Cutting Data SNAP¹

Material	Condition	Tensile strength (N/mm ²)	Hardness HB	SNAP 2/3/4		SNAP 5/8/12/20 GS	
				Cutting speed (m/min)	Feed (mm/rev)	Cutting speed (m/min)	Feed (mm/rev)
Unalloyed steel		<500	<150	40-70	0.02-0.1	40-70	0.1-0.3
Cast steel*		500 - 850	150 - 250	40-70	0.02-0.1	40-70	0.1-0.3
Grey cast iron*		<500	<150	50-90	0.02-0.1	50-90	0.1-0.3
Ductile cast iron*		300 - 800	90 - 240	40-70	0.02-0.1	40-70	0.1-0.3
Low alloy steel	annealed	<850	<250	40-70	0.02-0.1	40-70	0.1-0.3
	tempered	850 - 1000	250 - 300	30-50	0.02-0.1	30-50	0.1-0.2
	tempered	>1000 - 1200	>300 - 350	30-50	0.02-0.1	30-50	0.1-0.2
High alloy steel	annealed	<850	<250	20-50	0.02-0.1	20-50	0.1-0.2
	tempered	850 - 1100	250 - 320	15-30	0.02-0.1	15-30	0.1-0.15
Stainless steel	ferritic	450 - 650	130 - 190	15-30	0.02-0.05	15-30	0.05-0.15
	austenitic	650 - 900	190 - 270	10-20	0.02-0.05	10-20	0.05-0.15
	martensitic	500 - 700	150 - 200	15-30	0.02-0.05	15-30	0.02-0.15
Special alloy (Inconel, titanium)		<1200	<350	10-20	0.02-0.05	10-20	0.02-0.1
Wrought or cast aluminium alloys				70-120	0.05-0.15	70-120	0.1-0.3
Copper alloy	Brass			60-90	0.02-0.05	60-90	0.05-0.15
	Bronze short-chipping			30-50	0.02-0.05	30-50	0.05-0.15
	Bronze long-chipping			20-30	0.02-0.05	20-30	0.05-0.15

*) We recommend using coolant when machining cast materials.

Material	Condition	Tensile strength (N/mm ²)	Hardness HB	SNAP 5 DF ²		SNAP 5 DR	
				Cutting speed (m/min)	Feed (mm/rev)	Cutting speed (m/min)	Feed (mm/rev)
Unalloyed steel		<500	<150	40-70	0.02-0.08	40-70	0.05-0.1
Cast steel*		500 - 850	150 - 250	40-70	0.02-0.08	40-70	0.05-0.1
Grey cast iron*		<500	<150	50-90	0.02-0.08	50-90	0.05-0.1
Ductile cast iron*		300 - 800	90 - 240	40-70	0.02-0.08	40-70	0.05-0.1
Low alloy steel	annealed	<850	<250	40-70	0.02-0.08	40-70	0.05-0.1
	tempered	850 - 1000	250 - 300	30-50	0.02-0.08	30-50	0.05-0.1
	tempered	>1000 - 1200	>300 - 350	20-40	0.02-0.06	20-40	0.05-0.06
High alloy steel	annealed	<850	<250	20-50	0.02-0.08	20-50	0.05-0.08
	tempered	850 - 1100	250 - 320	15-30	0.02-0.06	15-30	0.02-0.06
Stainless steel	ferritic	450 - 650	130 - 190	15-30	0.02-0.08	15-30	0.05-0.1
	austenitic	650 - 900	190 - 270	10-20	0.02-0.06	10-20	0.05-0.08
	martensitic	500 - 700	150 - 200	15-30	0.02-0.06	15-30	0.02-0.06
Special alloy (Inconel, titanium)		<1200	<350	10-20	0.02-0.06	10-20	0.02-0.06
Wrought or cast aluminium alloys				70-120	0.02-0.1	70-120	0.05-0.2
Copper alloy	Brass			60-90	0.02-0.08	60-90	0.05-0.1
	Bronze short-chipping			30-50	0.02-0.06	30-50	0.05-0.1
	Bronze long-chipping			20-30	0.02-0.06	20-30	0.05-0.1

¹) Please pay attention to the WARNING NOTICE on the bottom of page 127. *) We recommend using coolant when machining cast materials.

²) For cassette tool only - please refer to page 119